

**Aero Design Ltd.****Work Order Control Sheet****Work Order#:** 2016-131**Date Opened:** 30 September 2016 **Title:** Assembly**Aircraft OEM:** Bell **Aircraft Model:** 206B**Product Type:** Cargo Basket **Product Model:** Medium **Quantity:** 1**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)  
Additional Work Sheets (Standard Practice)  
Drawings (See List Below)  
Parts Distribution Sheet  
Sub Component Tags  
Completed Certification  
Time Sheet (R&D)  
Notes

Initial or N/A

DB
N/A
DB
DB
JC
JC
N/A
N/A

**Build Sheet Contents**

Tasks Initialled  
Dual Inspections Initialled

Initial or N/A

JC
JC

**Drawing List**

Drawing #	Rev #	Description	Initial or N/A
80310	0	Basket Assembly	DB
84240	0	Lid Brace Installation	DB
84255	2	Handle Installation	DB
84261	2	Handle Assembly	DB

**Traveller**

Install walkway on lid  
Install lid on basket body  
Re-tap mounting lug holes and install mount lugs  
Install handle brackets  
Install handle  
Install lid prop  
Install data plate

Initial or N/A

N/A
DB
DB
DB
DB
DB
DB

Work performed by:

Print: D. BartfaiSign: 

ICC / Dual Inspection performed by:

Print: J. ClarkeSign: 

Work Order closed by:

Print: J. ClarkeSign: 

Approved Manufacturing Facility 73-04

Form 20.D.03

**Component Completion**

Quantity Complete on This Work Order  
Quantity Incomplete on This Work Order  
Further Processing Required Before Release  
Release to Stock as Components

As Instructed

1
N/A
N/A
N/A

**Certification**

Form One Completed  
Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Placed in Stores for Distribution

Initial or N/A

JC
N/A
N/A
N/A
N/A

**Additional Documentation**

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

N/A
N/A
N/A

**Billing**

Local (Aero Design)  
Research and Development  
Third Party

Initial or N/A

JC
N/A
N/A

SCA: AD07Date: 30-Sep-16SCA: AD02Date: 30-Sep-16SCA: AD02Date: 11-Oct-16

Rev. Original 23 Sep 2014



## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity:	1	
PN:	MS20001P4-9600	
Aircraft:	Multiple	Model: Multiple
Description:	Hinge	
Supplier:	Bisco	
Color:	N/A	
WO#:	N/A	PO# 16030



## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

80327-01

Aircraft:

Bell

Model: 206B

Description:

Placard

Supplier:

N/A

Color:

N/A

WO#:

N/A

PO# 11102



## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity: 1  
PN: 80312-01  
Aircraft: Bell  
Description: Lid (MED)  
Supplier: Aero Design  
Color: White  
WO#: 2009-03

Model: 206B

PO# N/A



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: BASKET BODY (206B MED) No. of pieces: 1

Manufacturer: AERO DESIGN

Part No.: 80311-01 Serial / Batch No.: V/K

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2009-03

Remaining Tasks to be Performed: ASSEMBLY w/ LID

Signature: [Signature]

Date: 09 AUG 2013 Lic. No. / ACA

In Process



## **Aero Design Ltd.**

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

AMF 73-04

### **Remarks**

**In Process**

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## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: lever assy. 4/H No. of pieces: 37

Manufacturer: Aero Design Ltd.

Part No.: 84261-02 Serial / Batch No.: \_\_\_\_\_

TTSN: N/A TSO: N/A Rem.: N/A

Work Order No.: 2015-42

Remaining Tasks to be Performed: Sand blast, drill bushing  
weld to tubing

Signature: Dave May

Date: May 2015 Lic. No. / SCA AD-05

In Process





## **Aero Design Ltd.**

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: [info@aerodesign.ca](mailto:info@aerodesign.ca)

**AMF 73-04**

### **Remarks**

**In Process**

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## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 49720-01

Aircraft: Bell

Model: 206B

Description: Forward Fitting

Supplier: N/A

Color: N/A

WO#: 2012-12

PO# N/A



## Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

49720-01

Aircraft:

Bell

Description:

Forward Fitting

Model: 206B

Supplier:

N/A

Color:

N/A

WO#:

2012-12

PO# N/A



## Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity: 1  
PN: 49721-01

Aircraft: Bell

Model: 206B

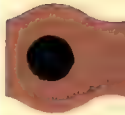
Description: AFT Fitting (RH)

Supplier: Aero Design

Color: N/A

WO#: 2012-12

PO# N/A





## Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: 49721-02

Aircraft: Bell

Model: 206B

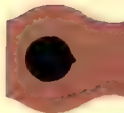
Description: AFT Fitting (LH)

Supplier: Aero Design

Color: N/A

WO#: 2012-12

PO# N/A





## Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

49721-~~03~~ 04 JC.

Aircraft:

Bell

Model: 206B

Description:

Pad

Supplier:

Aero Design

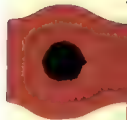
Color:

N/A

WO#:

2012-12

PO# N/A





## Aero Design Ltd.

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity:

1

PN:

49721-0304 JC.

Aircraft:

Bell

Model: 206B

Description:

Pad

Supplier:

Aero Design

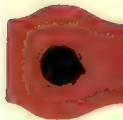
Color:

N/A

WO#:

2012-12

PO# N/A



[illegible]



## CARGO BASKET HANDLE FABRICATION

### General

These instructions apply to all cargo basket handle assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

All Models: 84261, Rev. 1

Work Order: 2016-131

Complete  
(initial or SCA #)

Date Open: \_\_\_\_\_

#### 1. Weld Lever Assembly – handle lever jig required

- Set MS20615-4M3 monel rivet into socket in jig
- Set 36274-01 bushing into socket in jig
- Set 84261-01 lever onto handle jig, with rivet and bushing protruding into lever.
- TIG weld around bushing using ER308L rod.
- Fuse weld rivet to lever. Additional ER308L rod may be used if required.
- Repeat steps a-f using hole/socket on opposite side of jig to make opposite lever assembly.
- Record material POs on attached material list.

Prev. C/W

AD  
73-04  
07

#### 2. Clean up

- Clean lever assembly by media blasting with glass bead.
- Drill out lever bushing to O (0.316) on lathe:
  - Grasp bushing in chuck, ensure rivet clears between the jaws.
  - Run at 300 RPM.
  - Apply a drop of Rapid-Tap to drill.
- De-burr.

AD  
73-04  
07

#### 3. Fabricate Handle Assembly

- Temporarily install handle levers (from step 2) on lid assembly. Ensure long side of handle bushings are on INSIDE (pointing together).
- Measure across TOP side of levers.
- Cut handle tubing to length measured.
  - Handles under 40" long: 1.0" x 0.035 round tube
  - Handles over 40" long: 1.0" x 0.065 round tube
- De-burr tube.
- Insert tube into handle levers. Tap with a plastic mallet to seat tube flush with lever. Raise handle to ensure both levers touch stops to check alignment.
- Record material PO on attached material list.

AD  
73-04  
05

#### 4. Weld Handle Assembly

- Fuse tube to lever on both ends. Ensure levers are parallel.

AD  
73-04  
06

#### 5. Clean up

- Clean welded area with scotch-brite.

#### 6. Final Inspection –

To be completed by a different person than the previous steps.

- Welds for complete and handle for fit.
- Tag complete and inspected parts in preparation for installation.

AD  
73-04  
02

Work Order: 2016-131Date Opened: Sept. 2016Material Tracking Sheet  
Bell 206B  
Medium Basket Handle Assembly

1 of 1

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>i</u>	84261	<b>84261-01</b>	<b>Handle Assembly</b>		
<b>Step 1</b>				<i>Weld Lever Assembly</i>		<u>2015-43</u>
	. 2		84265-01	Lever	304 Stainless, 0.105 Sheet	<u>2015-42</u>
	. 2		36274-01	Bushing	304 Stainless, 7/16" x 0.065 Rnd. Tube	
	. 2		MS20615-4M3	Rivet		
	. A/R		--	Welding Rod	ER308L TIG Rod	<u>14028</u>
<b>Step 2</b>				<i>Clean Up</i>	<i>None</i>	
<b>Step 3</b>				<i>Fabricate Handle Bar</i>		
	. 1		36277-01	Handle Bar	304 Stainless, 1.0 x 0.035 Rnd. Tube	<u>15073</u>
<b>Step 4</b>				<i>Weld Handle Assembly</i>	<i>None - Fuse weld, no rod req.</i>	
<b>Step 5</b>				<i>Clean Up</i>	<i>None</i>	
<b>Step 6</b>				<i>Inspection - Final Assembly</i>	<i>None</i>	

Order: 2016-131

Material Tracking Sheet  
Bell 206B  
Medium Basket Assembly

1 of 2

Date Opened: \_\_\_\_\_

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	1		80310-01	<b>Cargo Basket Assembly</b>		
<b>Step 1</b>				<i>Lid Assembly</i>		
	. 1		80312-01	Basket Lid Assembly		2009-03
Step 1.a.	. . 3		49205-14	Bumper	Argus Industries Bumper	
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
Step 1.b.	. . 1		80327-01	Placard (right)	0.063 Sheet, 6061-T6 Aluminum	11102
	. . 4		CR3213-4-02	Cherry Rivet		15086
Step 1.c.	. 1		70405-01	Lid Step Modification		
(option)	. . 1		70405-04	Tread Plate	3003 Aluminum Tread Plate, 0.063"	
	. . A/R		CR3213-4-02	Cherry Rivet		
	. . A/R		--	Sealant	Commercial Silicone RTV sealant	
<b>Step 2</b>				<i>Basket Assembly</i>		
Step 2.a.	. 1		80311-01	Basket Body Assembly		2009-03
	. . 4		96710-01	Fitting	Alternate: Ancra 40088-14	
	. . 8		NAS1149F0663P	Washer		
<b>Step 3</b>				<i>Hinge Installation</i>		
	. 1		MS20001P4	Piano Hinge	71"	16030
	. 8		CR3523-5-02	Cherry Rivet		15031
	. A/R		CR3213-5-02	Cherry Rivet		15086
<b>Step 4</b>	. 1		84255-01	<i>Handle Installation</i>		
Step 4.a.	. . 2		84267-01	Bracket	Delrin, 3/4" Sheet	2016-37
	. . 4		AN3-11A	Bolt		
	. . 8		NAS1149F0363P	Washer		
	. . 4		MS21044N3	Nut		

Work Order: \_\_\_\_\_

Date Opened: \_\_\_\_\_

Material Tracking Sheet  
Bell 206B  
Medium Basket Assembly

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 4.b.	1		84261-01	Handle Assembly		<i>See attached</i>
	2		36278-01	Spring (1 left, 1 right)	304 Stainless, 1/16" Dia Music Wire	
	2		36275-01	Bushing	Brass, 5/16" Dia	
	2		AN3-12A	Bolt		
	4		NAS1149F0363P	Washer		
	2		MS21044N3	Nut		
Step 5				<i>Lid Brace Installation</i>		
	1		36280-01	Brace Assembly		<i>2016-32</i>
	1		AN3-15A	Bolt		
	1		AN3-17A	Bolt		
	2		AN970-3	Washer		
	3		NAS1149F0363P	Washer		
	2		MS21044N3	Nut		
Step 6						
				<i>Inspection</i>	<i>None</i>	

WO#

Approved Manufacturing Facility 73-04

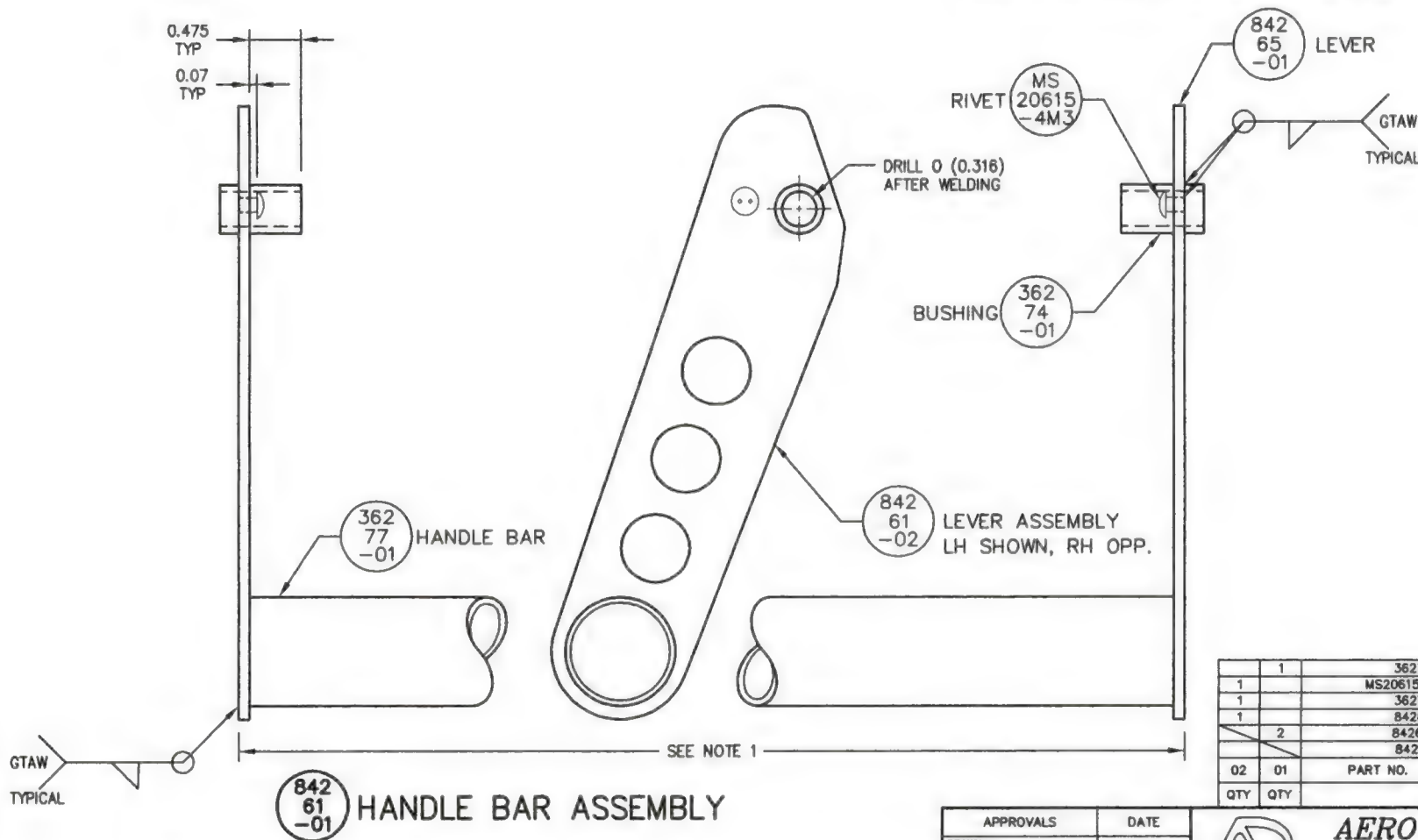
Form 20.F.06

Rev. Original 27 May 2013



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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED: LEVER ASSEMBLY ASSIGNED P/N	BJC	MAR 13/14



NOTES:

1. LENGTH OF HANDLE TO BE DETERMINED BY BASKET ASSEMBLY DRAWING.
2. REMOVE ALL BURRS AND SHARP EDGES.
3. WELDING TO BE COMPLETED BY GTAW METHOD TO AMS2685C USING ER308L ROD.

QTY	QTY	PART NO.	DESCRIPTION
1	1	36277-01	HANDLE BAR
1		MS20615-4M3	RIVET (MONEL)
1		36274-01	BUSHING
1		84265-01	LEVER
2		84261-02	LEVER ASSEMBLY (RH/LH)
2		84261-01	HANDLE BAR ASSY

APPROVALS	DATE
DRAWN: R. RATHWELL	JUNE 18/09
CHECKED: E. BURGAIN	

UNLESS OTHERWISE SPECIFIED  
DIMENSIONS ARE IN INCHES.  
TOLERANCES ON:  
DECIMALS ANGLES  
X.XXX ±0.010 ±1/2°  
X.XX ±0.03  
X.X ±0.1



**AERO DESIGN LTD.**

9688A MALASPINA ROAD  
POWELL RIVER, BC, CANADA, V8A 0G3  
TEL: 504.688.8376 www.aerodesign.ca

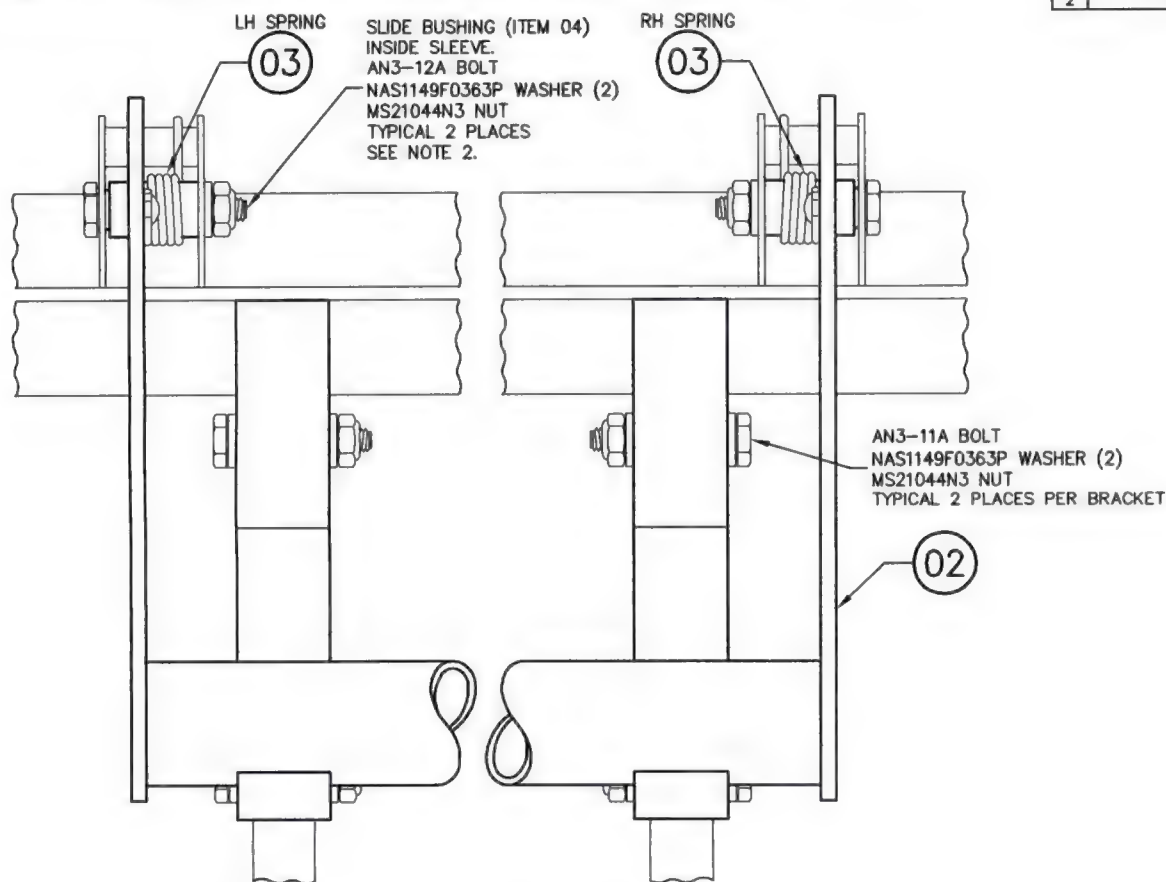
**HELICOPTER CARGO BASKET  
HANDLE BAR ASSEMBLY**

SCALE	DWG. SIZE	DWG. NO.	REV.
SCALE 1 : 1	A3	84261	2

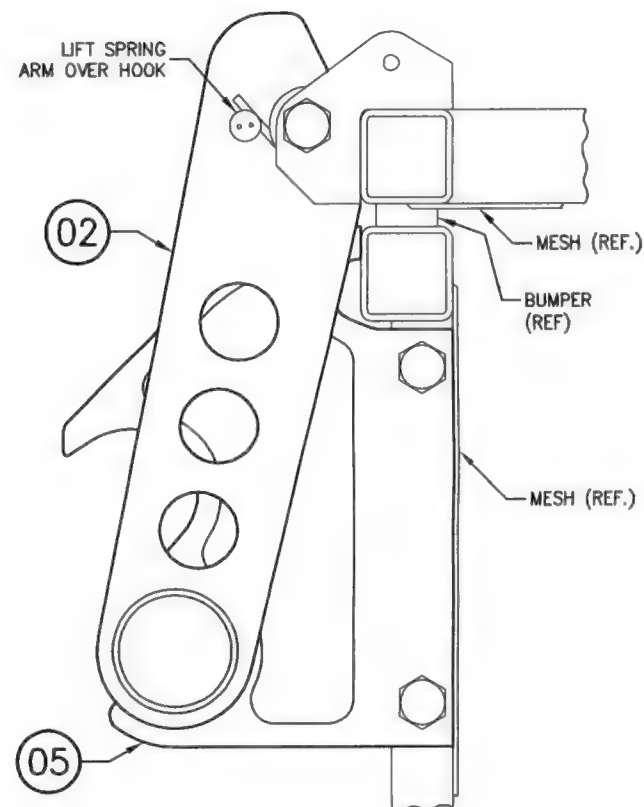
SHEET 1 OF 1

NOTES:

1. THIS DRAWING IS AN ALTERNATE CONFIGURATION FOR THE HANDLE INSTALLATION SHOWN ON DRAWING 36255.
2. GREASE BUSHING (ITEM 04) USING MOBILGREASE 28 OR EQUIVALENT PRIOR TO INSTALLATION.



01 HANDLE INSTALLATION



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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE - CREATED FROM 36255	BJC	NOV 03/09
1	HANDLE END BRACKETS FLIPPED	BJC	SEPT 19/11
2	TITLE BLOCK UPDATED; ADD NOTE 2; HARDWARE UPDATED	BJC	MAR 13/14

A/R	MOBILGREASE 28		GREASE	MIL-PRF-B1322F
4	AN3-11A		BOLT	
2	AN3-12A		BOLT	
10	NAS1149F0363P		WASHER	
6	MS21044N3		NUT	
2	84267-01	05	BRACKET	
2	36275-01	04	BUSHING	
2	36278-01	03	SPRING (1 LH, 1 RH)	
1	84261-01	02	HANDLE BAR ASSEMBLY	
	84255-01	01	HANDLE INSTALLATION	
01	PART NO.	ITEM	DESCRIPTION	MATERIAL
QTY.	LIST OF MATERIALS			

APPROVALS		DATE
DRAWN:	JEFF CLARKE	03 NOV 2009
CHECKED:	E. BURGON	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:		
DECIMALS		ANGLES
X.XXX	±0.010	±1/2°
X.XX	±0.03	
X.X	±0.1	



**AERO DESIGN LTD.**

9888A MALASPINA ROAD  
POWELL RIVER, BC, CANADA, V8A 0G3  
TEL: 804.463.2376 www.aerodesign.ca

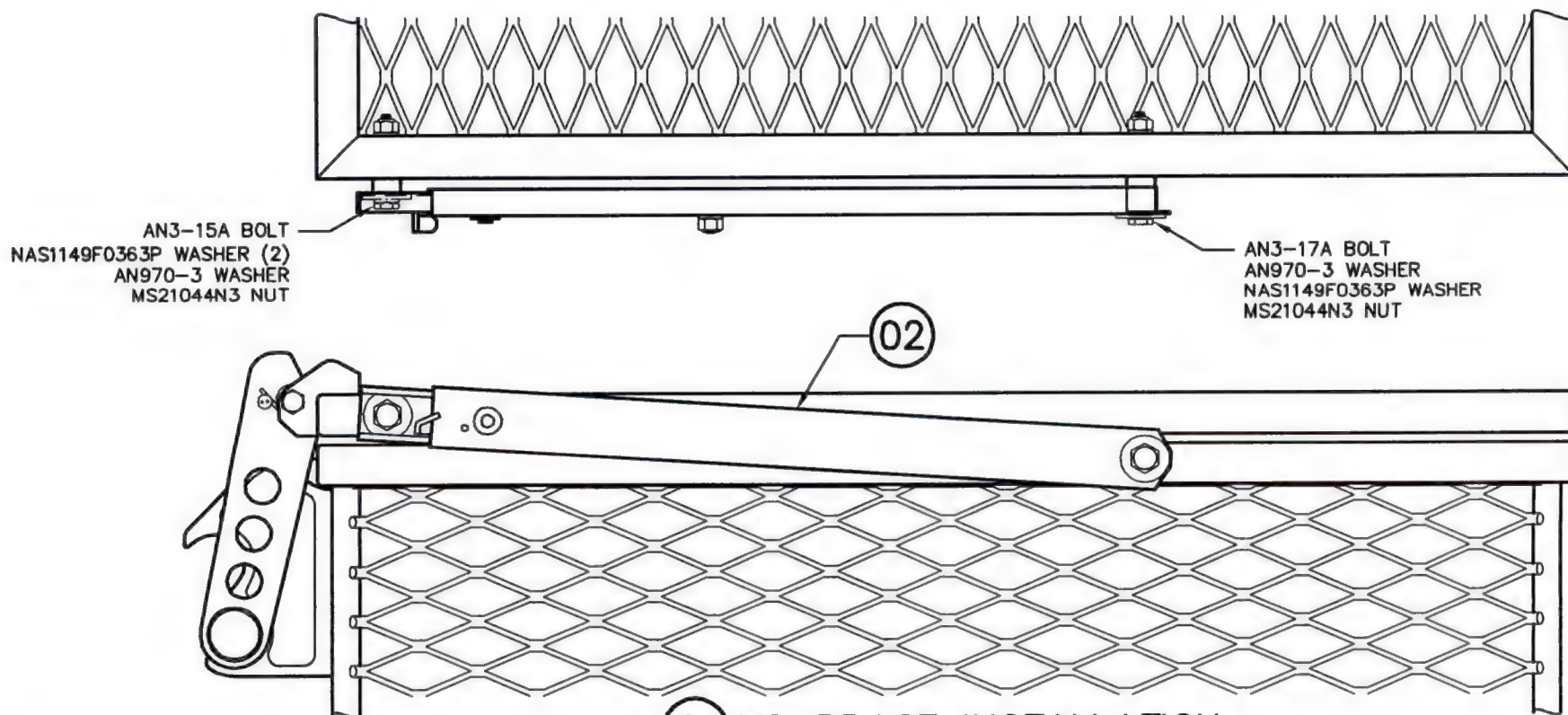
**HELICOPTER CARGO BASKET  
HANDLE BAR INSTALLATION**

SCALE 1 : 1	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A3	84255	2



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REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE	*	*



## (01) LID BRACE INSTALLATION

### NOTES

- THIS DRAWING APPLIES TO ALL AERO DESIGN LTD. CARGO BASKET ASSEMBLIES.  
LID PROP IS TO BE INSTALLED ON THE FORWARD END OF THE BASKET AS INSTALLED ON THE HELICOPTER.

2	MS21044N3		NUT
3	NAS1149F0363P		WASHER
2	AN970-3		WASHER
1	AN3-17A		BOLT
1	AN3-15A		BOLT
1	36280-01	02	LID BRACE ASSEMBLY
1	84240-01	01	LID BRACE INSTALLATION
01	PART NO.	ITEM	DESCRIPTION
QTY.	LIST OF MATERIALS		

APPROVALS	DATE
DRAWN: JEFF CLARKE	21 MAY 2014
CHECKED: JASON REKVE	21 MAY 2014
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:	
DECIMALS	ANGLES
X.XXX ±0.010	±1/2°
X.XX ±0.03	
X.X ±0.1	



## AERO DESIGN LTD.


9888A MALASPINA ROAD  
POWELL RIVER, BC, CANADA, V8A 0G3  
TEL: 604.453.2378 www.aerodesign.ca

### HELICOPTER CARGO BASKET ALL MODELS LID BRACE INSTALLATION

NOT TO SCALE	DWG. SIZE	DWG. NO.	REV.
SHEET 1 OF 1	A4	84240	0

REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0			

<b>AERO DESIGN LTD.</b> CONSULTING ENGINEERS, TRANSPORT CANADA APPROVALS, DAR 290 5013 - 50TH AVENUE N.E., CALGARY, ALBERTA, CANADA, T2E 6T7 tel: (403) 286-9087 fax: (403) 820-9388 <a href="mailto:aerodesign@tcoupsnet.ca">aerodesign@tcoupsnet.ca</a>			
BELL 206B QUICK RELEASE CARGO BASKET CARGO BASKET ASSEMBLY			
SCALE 1 : 4	DRWG. SIZE	DRWG. NO.	REV.
SHEET 1 OF 1	A1	80310	0

1. Approving Civil Aviation Authority/Country <b>Transport Canada</b>		2. AUTHORIZED RELEASE CERTIFICATE FORM ONE			3. Form Tracking No. <b>2016-0191</b>
4. Organization Name and Address <b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>					5. Work Order/Contract/Invoice <b>WO 2016-131</b>
6. Item <b>1.</b>	7. Description <b>Cargo Basket Ass'y</b>	8. Part Number <b>80310-01</b>	9. Qty. <b>1</b>	10. Serial/Batch No. <b>80301-08</b>	11. Status/Work <b>New</b>
12. Remarks					
13a. Certifies that the items identified above were manufactured in conformity to:  <input checked="" type="checkbox"/> Approved design data and are in condition for safe operation. <input type="checkbox"/> Non approved design data specified in block 12.			14a. <input type="checkbox"/> CAR 571.10 Maintenance Release <input type="checkbox"/> Other regulation specified in block 12 Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations.		
13b. Signature  <b>AD 73-04 02</b>		13c. Approved Organization Number <b>AMF 73-04</b>		14b. Signature	
13d. Name <b>Jeff Clarke - AD02</b>		13e. Date (dd/mm/yyyy) <b>07 Oct 2016</b>		14c. Approved Organization Number	
				14d. Name	
				14e. Date (dd/mm/yyyy)	
<p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p>					

*BLACK SWAN HELICOPTERS*



## **CARGO BASKET ASSEMBLY - COMMON**

### **General**

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details:

#### **Bell 206L/407 – Right side only**

69810, Revision 3 – Standard Low Mounted Basket  
94510, Revision 0 – Extra-Wide Low Mounted Basket  
94610, Revision 0 – Extra-Wide Low Mounted Ski Basket  
76610, Revision 0 – High Mounted Ski Basket

#### **Eurocopter AS350/AS355 – left or right**

77610, Revision 1 – Short Basket  
76410, Revision 3 – Medium Basket (left or right)  
78410, Revision 2 – Long Basket  
94010, Revision 0 – Extra Large (ski) Basket

#### **Robinson R44 – left or right**

90610, Revision 0 – Standard Basket (left or right)

#### **Bell 206B – right side only**

80210, Revision 0 – Short Basket  
80310, Revision 0 – Medium Basket  
81110, Revision 0 – Long Basket

#### **Bell 429 – right or left**

95911, Revision 0 – Standard Basket

#### **Bell Medium – left or right**

75111, Revision 0 – Standard Basket  
95511, Revision 0 – Extra Large (ski) Basket

#### **MD600**

82811, Revision 0 – Standard Basket

#### **Options**

70405, Revision 3? – Lid Walkway

## CARGO BASKET ASSEMBLY - COMMON

Complete  
(initial or SCA #)

Work Order: 2016-131

Date Open: \_\_\_\_\_

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### 1. Lid Assembly

- a. Install lid bumpers on bottom.
  - i. Fill bumper holes with RTV silicone sealant.
  - ii. Insert 49205-14 lid bumper, 3 or 4 places per lid.
- b. Install placard on bracket on top of lid.
  - i. Locate placard on bracket.
  - ii. Drill #30 through placard and bracket, using holes in placard.
  - iii. Remove placard and de-burr holes in placard and on bracket.
  - iv. Locate placard on bracket, and cleco in place.
  - v. Rivet placard with four CR3213-4-02 CherryMax rivets.
- c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)
  - i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
  - ii. Pull tread plate from stock. Shear tread plate to length.
  - iii. De-burr edges of tread plate with scotch-brite disc on die-grinder.
  - iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
  - v. Mark and drill #30 holes:
    1. 0.25" from edge of tread plate, centre on cross members (0.38")
    2. 0.25" from edge of tread plate, middle of each walkway stringer
  - vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using 1/4" piloted counter bore on both sides.
  - vii. De-burr holes in lid tubes.
  - viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
  - ix. Set tread plate in place, secure with clecos if necessary.
  - x. Rivet placard with CR3213-4-02 CherryMax rivets
- d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list

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### 2. Body Assembly

- a. Install attachment fittings
  - i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
  - ii. Run 3/8-24 tap into attachment lugs to clear threads.
  - iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
  - iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
    1. 90610 (Robinson R44) basket only:
      - a. Install 1 fitting 906?? in lower forward attachment lug only.
      - b. Install 3 96710-01 fittings in remaining locations.
  - v. Torque to ??

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- b. 946 Basket Only: Install Cutout Brace – *must be completed after hinge installation*
  - i. Locate 94621-01 Brace over aft cross tube cutout
  - ii. Install two AN4-6A bolts and two AN4-30A bolts with NAS1149F0463P washers.
  - iii. Torque AN4 bolts to ??
- c. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

### 3. Hinge Installation

#### a. Prepare hinge.

- i. Cut hinge to length:
  - 1. 776, 906 – 54"
  - 2. 751, 803 – 70"
  - 3. 698, 764, 945 – 72"
  - 4. 784 – 90"
  - 5. 940, 946, 959 – 95"
- ii. Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.

#### b. Install hinge on basket

- i. Locate hinge on basket (standard baskets)
  - 1. centre fore/aft
  - 2. 0.15" – 0.18" up from bottom edge
- ii. Locate hinge on basket (extra wide baskets)
  - 1. centre fore/aft
  - 2. set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
- iii. Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
- iv. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
- v. Remove hinge and de-burr holes in hinge and basket rim.
- vi. Cleco hinge to basket with 5/32 clecos.
- vii. Install hinge with CherryMax rivets
  - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
  - 2. CR3213-5-02 aluminum rivets – all other locations

#### c. Install lid on basket

- i. Locate lid on hinge (all baskets)
  - 1. center fore/aft
  - 2. 0.15" – 0.18" down from top edge
- ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
- iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
- iv. Remove hinge and de-burr holes in hinge and lid rim.
- v. Cleco lid to hinge with 5/32 clecos.
- vi. Install hinge with CherryMax rivets
  - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
  - 2. CR3213-5-02 aluminum rivets – all other locations

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- d. Record PO of hinge and rivets on attached material tracking list.

### 4. Install Handle

#### a. Install handle brackets.

- i. Set 84267-01 handle bracket on provisions in hoops, 2 places.
- ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
- iii. Torque AN3 bolts to ??.

#### b. Install handle

- i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly.
- ii. Grease two 36275-01 bushings with ???. Insert into bushings of handle assembly.
- iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
- iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
- v. At first end, remove bolt and repeat step iv.
- vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
- vii. Torque AN3 bolts to ??.

#### c. Check handle

- i. Operate handle to ensure handle does not bind and springs hold handle in.
- ii. Snap handle into brackets to ensure handle locks.

- d. Record PO/WO of all parts used in steps above on attached material tracking list.

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### 5. Install lid brace

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to ??
- f. Record PO/WO of all parts used in steps above on attached material tracking list.



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### 6. Final Inspection

Dual inspection by a different person than assembled the basket.

a. Check for general condition and correct assembly:

- i. Bolts are tight
- ii. Rivets are installed correctly
- iii. Handle operates correctly
- iv. Lid brace operates correctly

b. Check that PO/WO numbers have been recorded.

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